

SHR 06/05 12:05

Dart Aerospace Ltd.

Date: Friday, 01/05/2009 7:36:35 AM  
Use: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GUIDE ASSEMBLY
<b>Job Number</b> : 47643	
<b>Estimate Number</b> : 13891	
<b>P.O. Number</b> :	<b>Part Number</b> : D3572044 GY
<b>This Issue</b> : 01/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3572 REV.D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : D
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/05/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 09-04-28 JLM Verified By:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Pick Packing Kit

2.0	D35723	Guide
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)  
GUIDE  
Batch: B40562 → 1 B45843

lpl09-05-04

3.0	D35725	Bracket
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 8.0000 Each(s)  
BRACKET  
Batch: B32415 → 7 (1 part scrap)

lpl09-05-04

4.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W
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**Comment:** Qty.: 2.3405 f(s)/Unit Total : 4.6809 f(s)  
6061-T6 Round Tube 1.00"x 0.188 wall  
Batch: 7109041

lpl09-05-04

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
1-Cut Tube D3572-1 as per Dwg D3572  
2-deburr both ends

lpl09-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3572-044 PAR #: N/A Fault Category: Prod/Fin. Ltg. NCR: (Yes) No DQA: D Date: 05/05/06  
D3572-0538  
 Resolution: PROCESS REVISED Disposition: SCRAP QA: N/C Closed: D Date: 09/05/06

NCR: <u>47643</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>9/5/04</u>	<u>7-0</u>	<u>D3572-2 Bracket was</u> <u>scraped due to welding</u> <u>in wrong angle.</u> <u>RL welder Didit And</u> <u>Dis. (and Natic)</u> <u>No positioning S.G.</u>	<u>CP</u> <u>G.O.S. 04</u> <u>pr</u> <u>05/04/06</u>	<u>Scrap and Destroy etc.</u> <u>Replac D3572-2</u> <u>B# B32415</u> <u>it's being made</u>	<u>lpc</u> <u>09.05.05</u>	<u>69.05.05</u>	<u>CP</u> <u>G.O.S. 04</u> <u>pr</u> <u>05/04/06</u>	<u>69.05.05</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 47643

Part Number: D3572044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/09/05/04 (X2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3572-3 guides and D3572-5 brackets as per Dwg D3572

A/R AL ROD

Batch: M111 385

Pl 09-05-05

(P10)  
Previous  
page

(X2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush at the ends of tube only

Pl 09-05-05

(X2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-05 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/09/05/05 (X2)

(-044)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD/F2

09/05/05

(X2)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:10

OVEN TEMPERATURE:

320°

FINISH TIME:

8:40

F2 09/05/06

(2)

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Drawing Name: GUIDE ASSEMBLY

Job Number: 47643

Part Number: D3572044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BK 09-05-6 (2)*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*260 ST*

*09/05/06 (2)*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

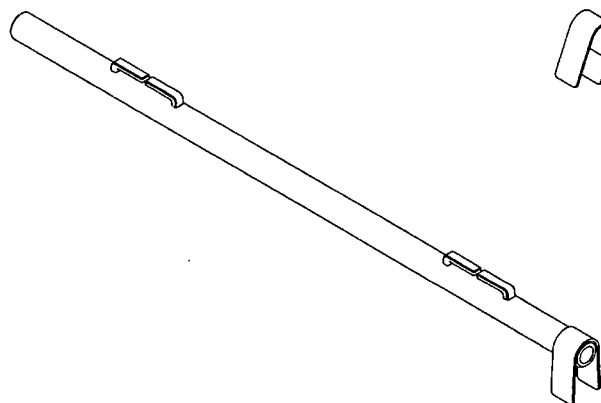
*09/05/06*

Job Completion

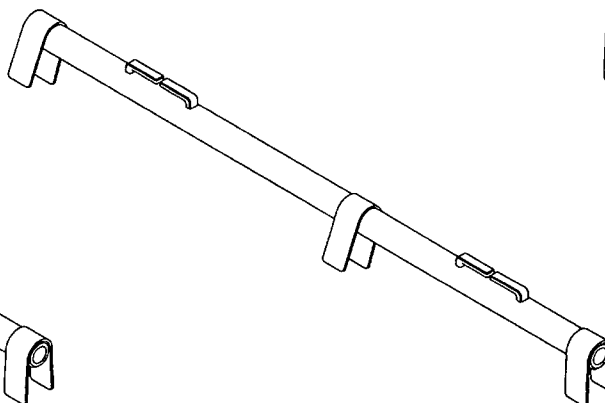


*MF 09-05-06*

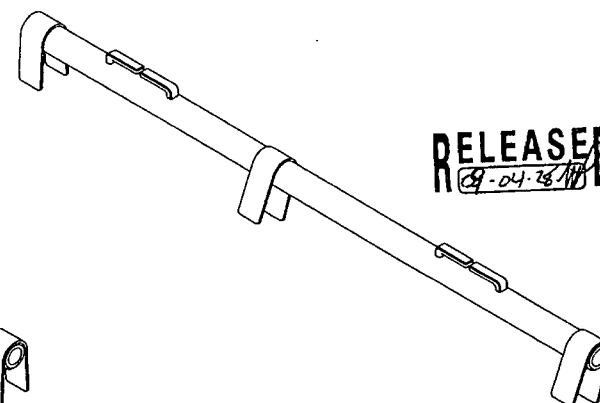
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



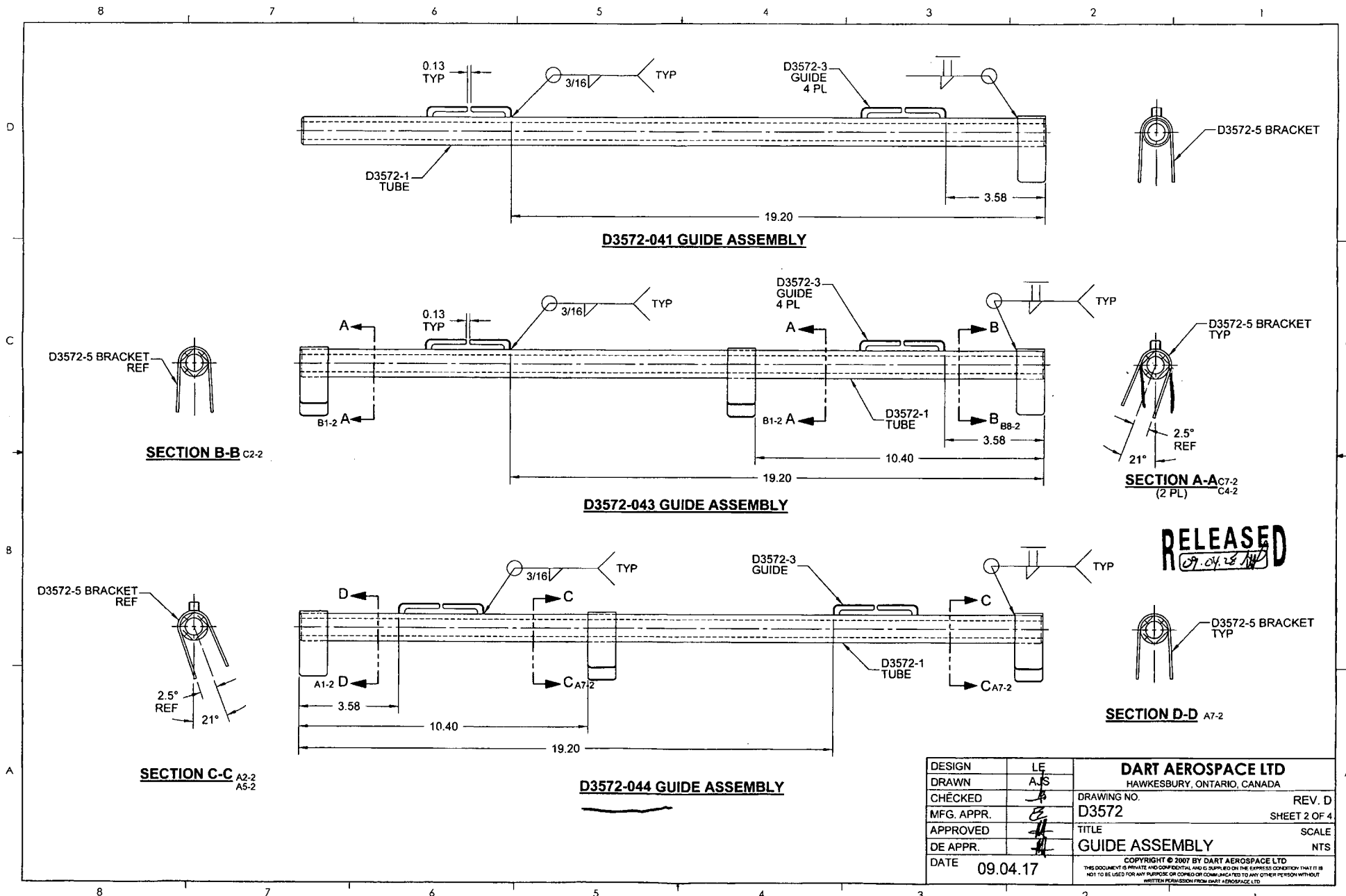
**D3572-044 GUIDE ASSEMBLY (UH-1)**

**RELEASED**  
09-04-2017

**NOTES:**

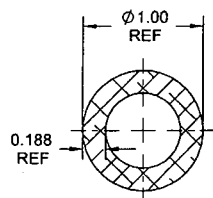
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.08.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3572</b> REV. D SHEET 1 OF 4 TITLE <b>GUIDE ASSEMBLY</b> SCALE NTS  <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.04.17		

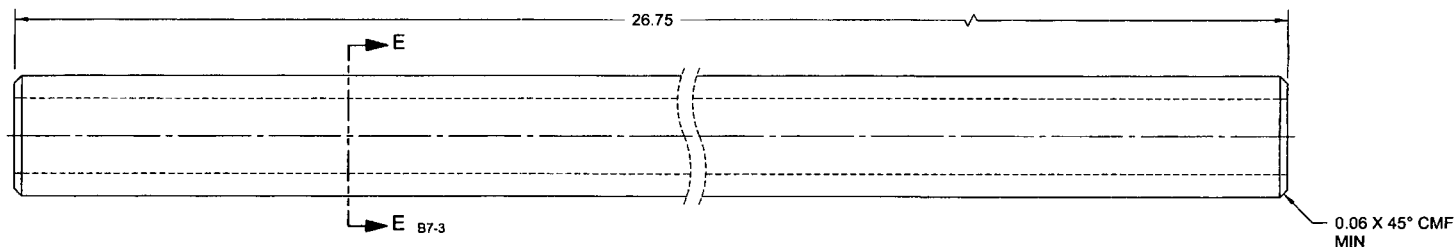


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09.04.17

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**SECTION E-E C5-3**



**D3572-1 TUBE**

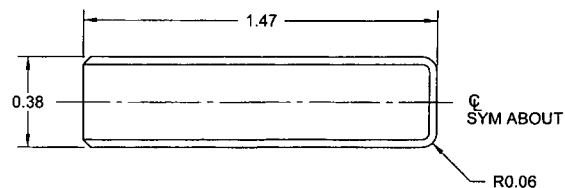
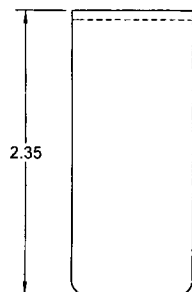
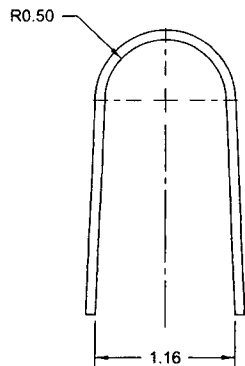
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09/04/17

**D3572-1 NOTES:**

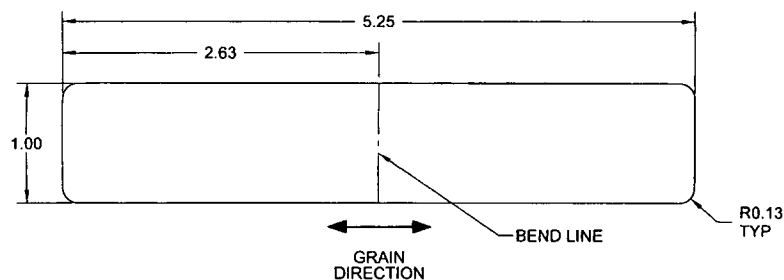
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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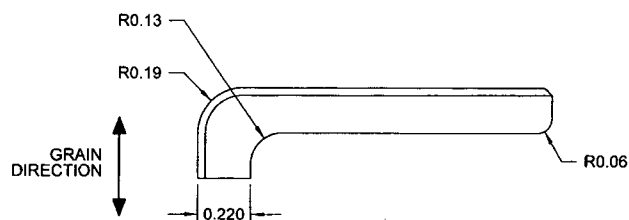
8 7 6 5 4 3 2 1



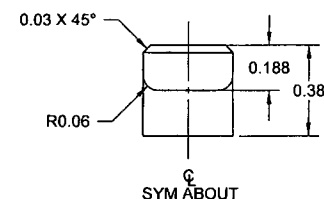
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**



**RELEASED**  
9/04/17

**D3572-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3572-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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8 7 6 5 4 3 2 1